

Date: Tuesday, 11/21/2006 11:34:32 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : BRACKET CLEVIS

Job Number : 29573

Estimate Number : 12498

P.O. Number : N/A

This Issue : 11/21/2006 S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A Type : SMALL /MED FAB

Previous Run : 29540

Part Number : D351613

Drawing Number : D3516 REV. B PRELIM

Project Number : N/A

Drawing Revision : B

Material : N/A

Due Date : 11/28/2006

Qty: 12 Um: Each

Written By :

Checked & Approved By :

Comment : Est Rev:A New Issue 06-06-09 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S11GA 304/316 .125 Sheet



Comment: Qty.: 0.0218 sf(s)/Unit Total: 0.2621 sf(s)

304/316 .125 Sheet 11GA

(M304S11GA)

Batch: m101463 m 06 11 22

(12)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3516

Dwg Rev: B

Prog Rev: Prel

m 06 11 22

(12)

2-Deburr if necessary

SAD 06/11/23

(12)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



m 06 11 22

(12)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAD 06/11/22

(12)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3516

SAD 06/11/23 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: TD Date: 06/11/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/29	5	1 part was out of tolerance	<u>AS</u> 06/11/29	Swap + destroy	<u>SB</u> 06/11/29	<u>AS</u> 06/11/29	<u>AS</u> 06/11/29	<u>AS</u> 06/11/29

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 11:34:33 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET CLEVIS

Job Number: 29573

Part Number: D351613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

NOV 11/29

(11)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

PD 06-11-29

(10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PD 06-11-29

(11)

Job Completion



W 06-11-29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

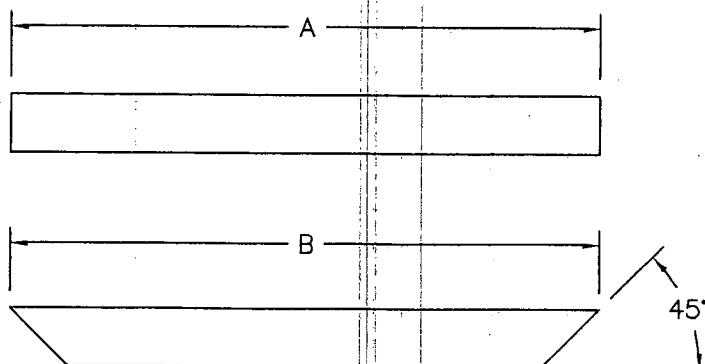
06.11.06

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3516	REV. B SHEET 1 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE NTS
A	06.06.21	NEW ISSUE	
B	06.07.25	ADD (4) D3516-13, (6) D3516-11 WAS (10), SEE TR-D119-756-1 REV. A	

PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3516-1	2	—	102.00	RIB
D3516-3	2	—	25.50	RIB
D3516-5	8	26.75	—	RIB
D3516-7	3	45.50	—	RIB
D3516-9	4	N/A	N/A	RIB
D3516-11	6	N/A	N/A	CLEVIS
D3516-13	4	N/A	N/A	CLEVIS
D2232-3	2	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D3442-1	2	N/A	N/A	SHIM

B



NOTES:

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING (REF. DART SPEC. M304TS0.750W.065)
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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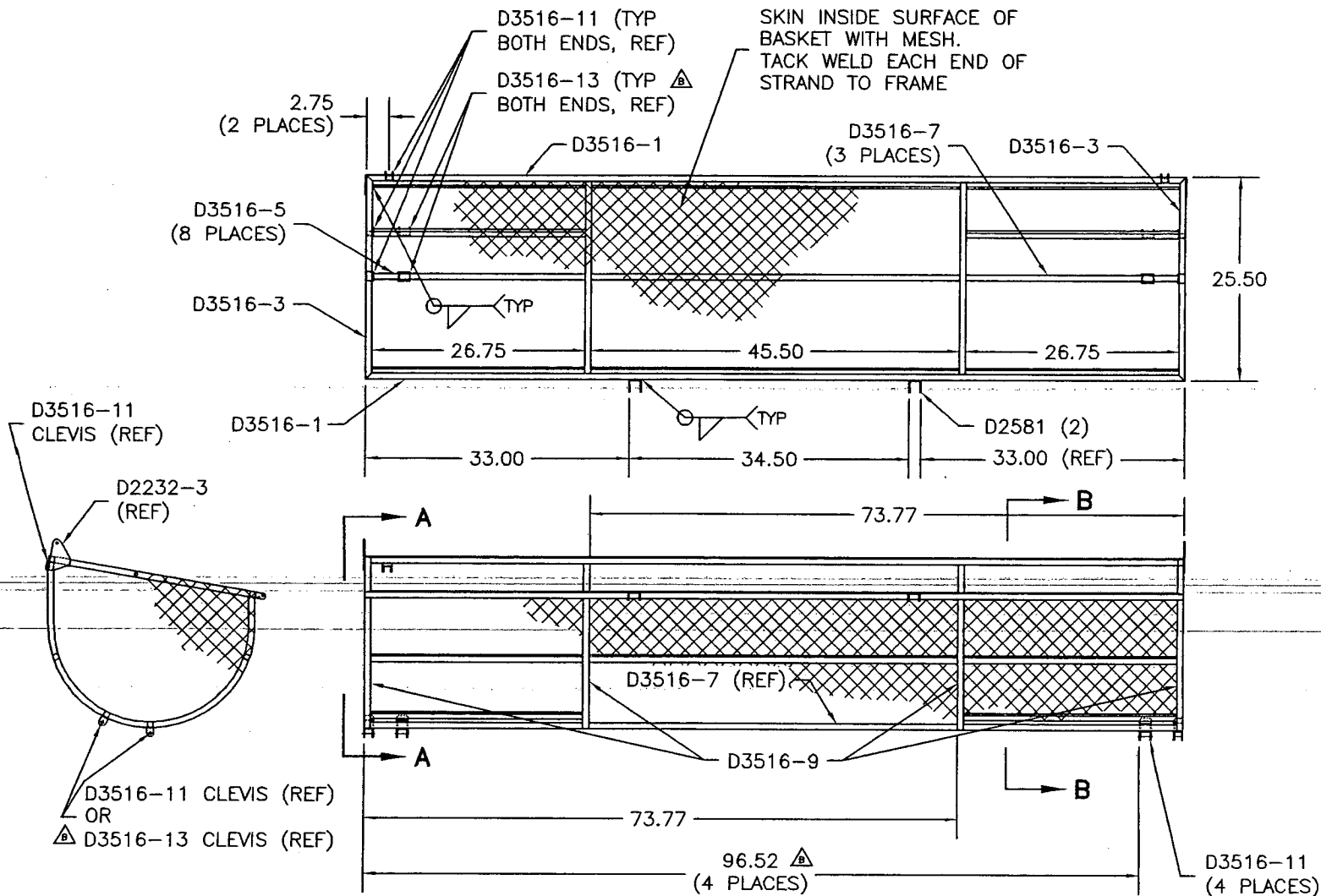
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PRELIMINARY ISSUE

06-11-06

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DATE	DRAWING NO.	REV. B
06.07.25	D3516	SHEET 2 OF 5
	TITLE	SCALE
	BASKET BASE ASSEMBLY (A119)	1:20



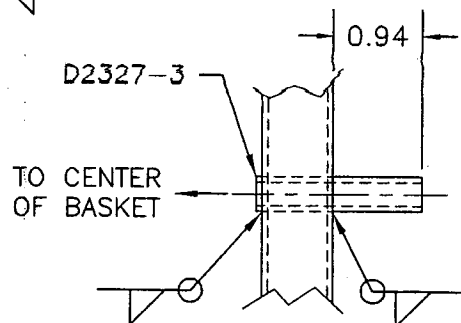
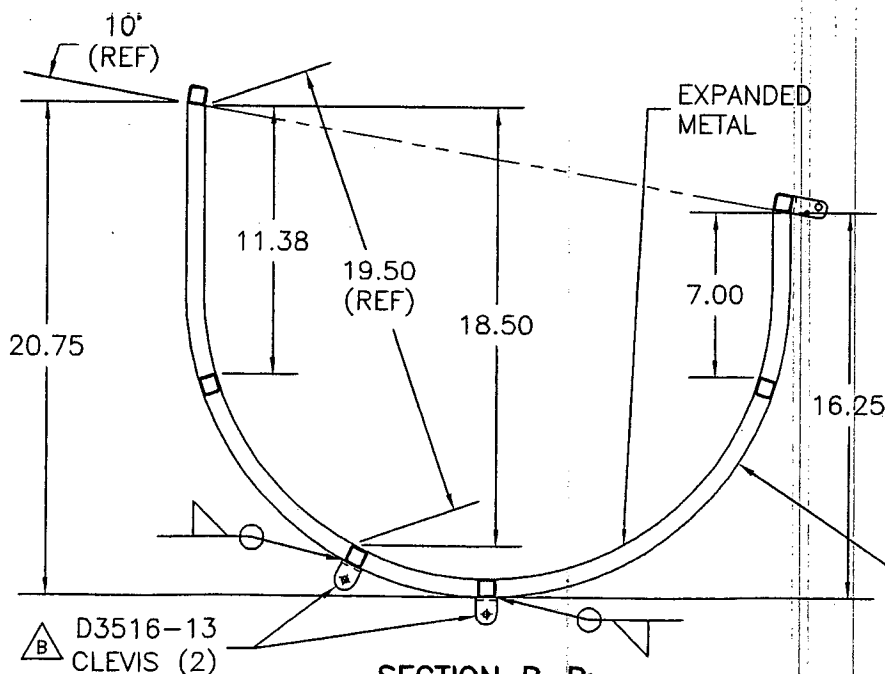
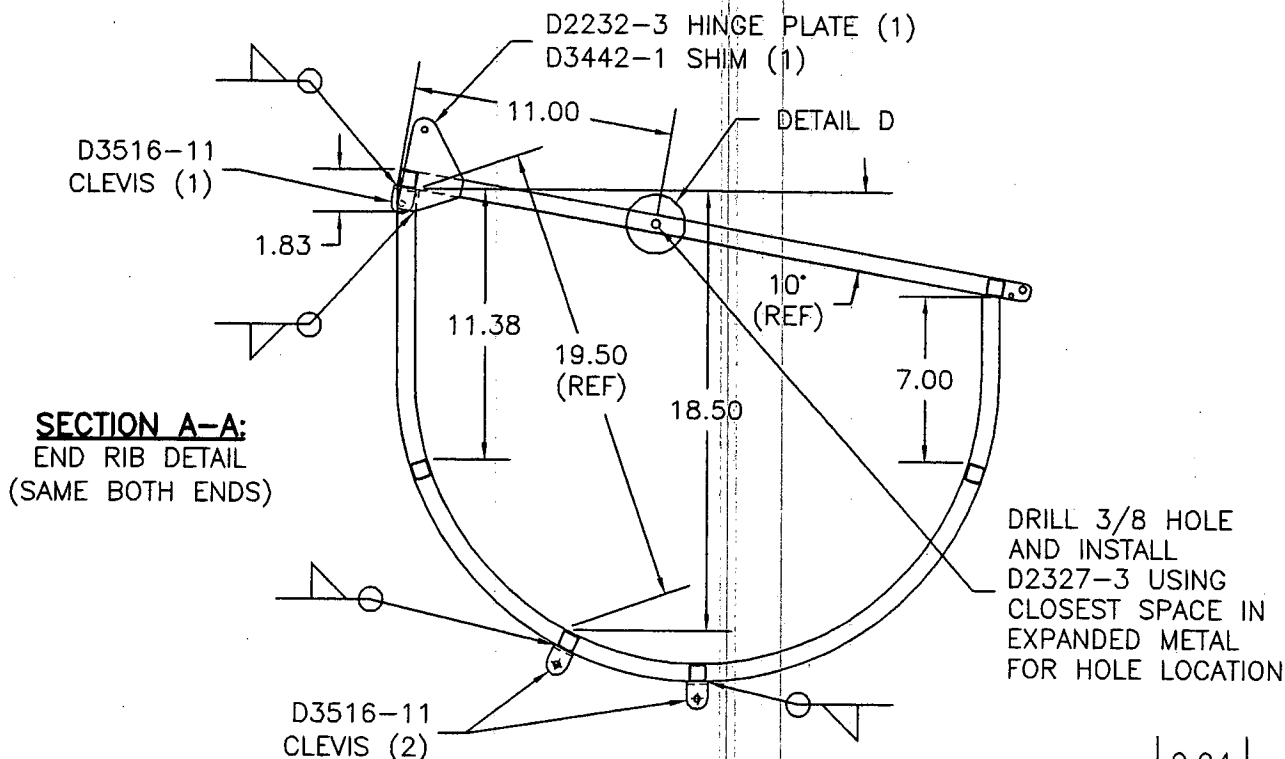
D3516-041 BASKET BASE ASSEMBLY

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DATE 06.07.25	TITLE BASKET BASE ASSEMBLY (A119)		SCALE 1:8



DETAIL D
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D3516-9 RIB
(MAKE FROM D2235-3)

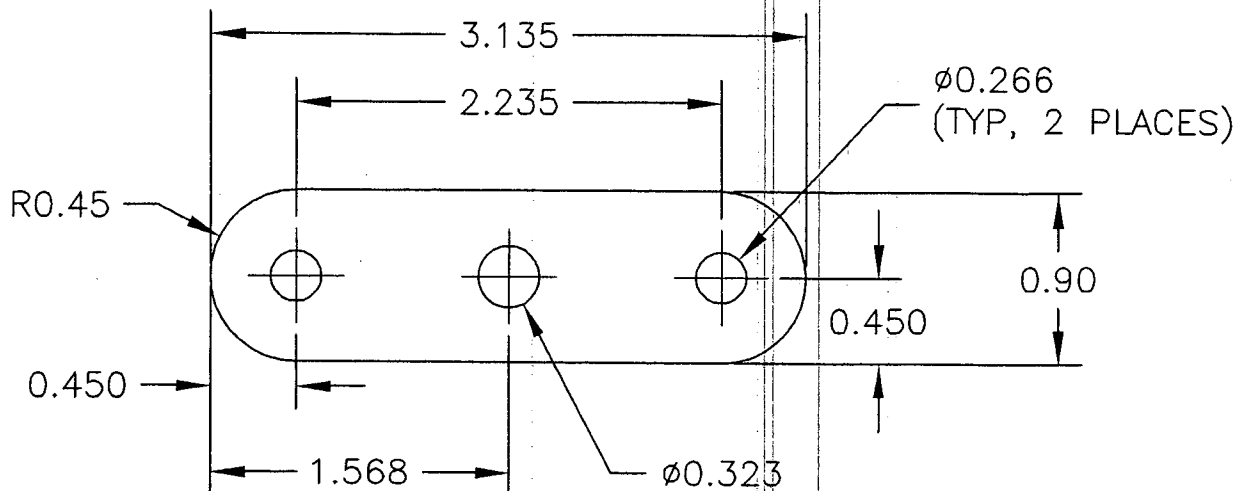
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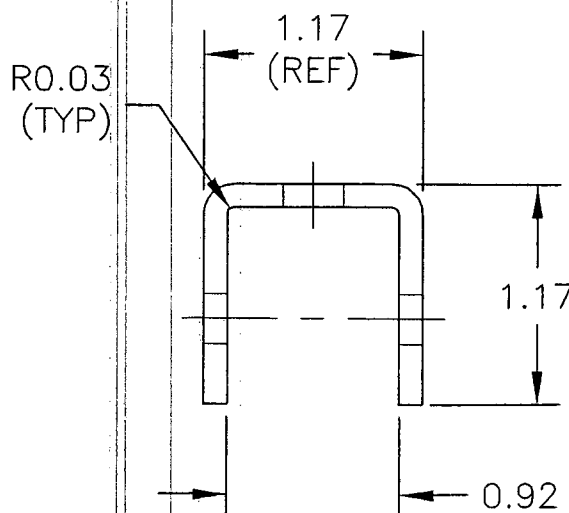
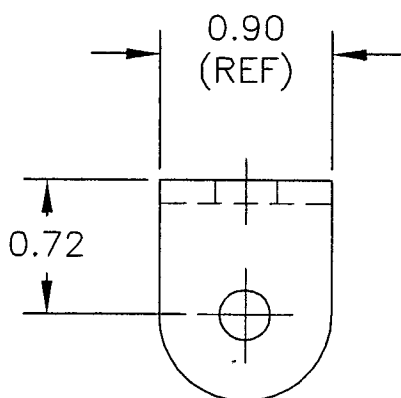
OC. KOG

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CHECKED	APPROVED	DRAWING NO. D3516	REV. B SHEET 4 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1



D3516-11F CLEVIS FLAT PATTERN

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)



D3516-11 CLEVIS BENDING DETAIL

- 1) MATERIAL: MAKE FROM D3516-11F
2) ALL DIMENSIONS ARE IN INCHES
3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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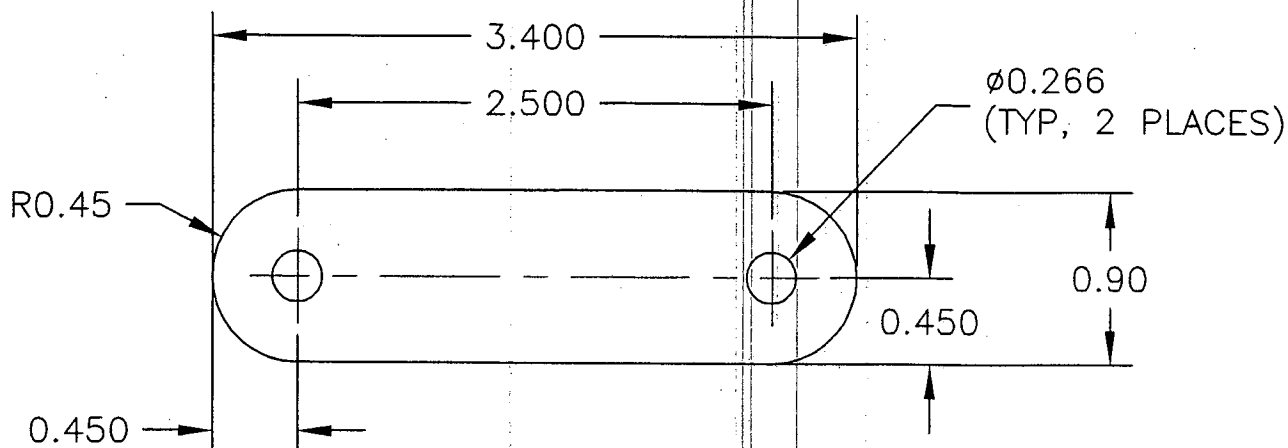
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PRELIMINARY ISSUE

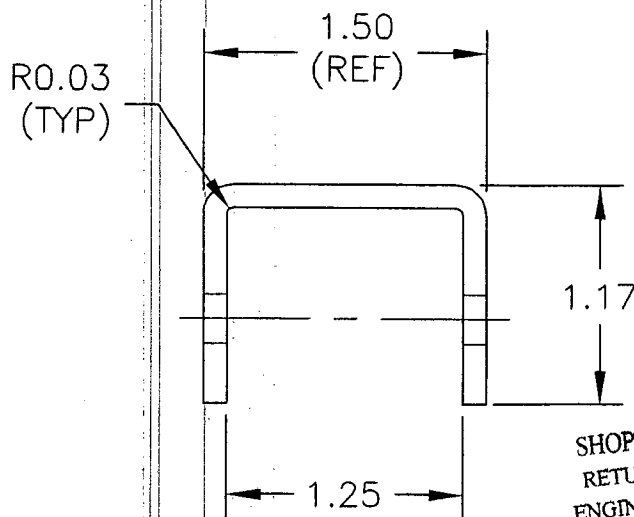
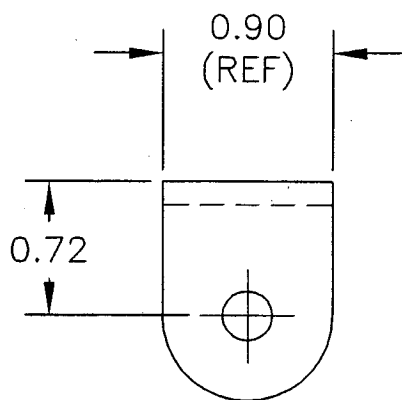
06.11.06

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CHECKED	APPROVED	DRAWING NO. D3516	REV. B SHEET 5 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1



D3516-13F CLEVIS FLAT PATTERN

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)



D3516-13 CLEVIS BENDING DETAIL

- 1) MATERIAL: MAKE FROM D3516-13F
2) ALL DIMENSIONS ARE IN INCHES
3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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